Date

Friday, 17/08/2007 11:20:29 AM

User:

Linda Lacelle

## **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 34074

**Estimate Number** 

P.O. Number This Issue

: 17/08/2007

S.O. No. : NA

Prsht Rev. First Issue

Type

: MACHINED PARTS

**Previous Run** 

Written By Checked & Approved By

Comment

Now machined in house.

NG

**Drawing Name** 

**Part Number** 

**Due Date** 

: D2652

: BUSHING

**Drawing Number** 

: D2652 REV A : N/A

**Project Number** 

**Drawing Revision** Material

: 20/09/2007

Qtv:

200 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

M303R0500 1.0

303 Round Bar 0.500"



Comment: Qty.:

0.0578 f(s)/Unit Total:

11.5500 f(s) M/0/4/8 x Goparts

Material:303 ss .500" Round Bar

(M303R0500)

Batch: M/049/9x110 ports

2.0

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

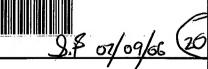
QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING RESOURCE #1



PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANG						
DATE STEP		PROCEDURE CHANGE	В	у О	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					- 1 - 11-			
Part No	•	PAR #· Fault Category:	NCP.	Ves (Nd	DOA	.5	Date:	Valia

QA: N/C Closed: \_\_\_\_ Date: \_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
DATE STE		Description of NC		Corrective Action Section B								
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
··		•										
				·								
				B								

NOTE: Date & initial all entries

Date:

Friday, 17/08/2007 11:20:29 AM

User:

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34074

Part Number: D2652

Job Number:



Seq. #:

**Machine Or Operation:** 

Comment: FINAL INSPECTION/W/O RELEASE

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Job Completion



u 77-9-87

Dart Ae	rospace Ltd								
W/O:			WORK ORDER CHANGES						
DATE	STEP	PR	OCEDURE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Category:	NCR: \	es No DC	A:	_ Date: _		
				Q	A: N/C Close	d:	_ Date: _		
NCR:		<u>.</u>	WORK ORDER NON-COM	IFORMANCE (N	ICR)	·····			

	WORK ORDER NON-CONFORMANCE (NCR)									
	Deceription of NC	Corrective Action Section B			Varification					
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
	14									
						-	į			
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	Q,		·							
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP  Description of NC Section A  Initial Chief Eng Corrective Action Section B  Initial Chief Eng Chief	STEP  Description of NC Section A  Initial Chief Eng Corrective Action Section B  Initial Chief Eng Chief Eng Chief Eng Corrective Action Section B  Verification Section C	STEP Description of NC Section A Chief Eng Corrective Action Section B Verification Section C Se			

NOTE: Date & initial all entries

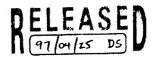
DART AEROSPACE LTD	Work Order:	34074
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

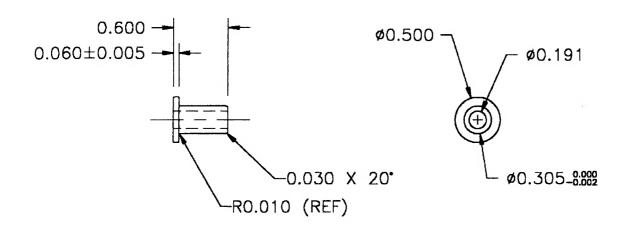
iopoction =g		T ARTICLE II	NSPECTI	ON CH	ECKLIST		
	)	First Arti	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	(	Comments
0.600	+/-0.010	g 600					
0.060	+/-0.005	, 600 , 060					
Ø0.305	-0.002/+0.000	. 3035					
Ø0.191	+0.005/-0.000	,193					
Ø0.500	+/-0.010	. 499					
0.030 x 20°	+/-0.010	1030×20					
R0.010	+0.010/-0.000	1030×20 1.004					
easured by:	20	Audited by:	XX	F	Prototype App	roval:	N/A
Date:	7/09/05	Date:	7/09/0			Date:	
ev Date	Change		/ /		R	evised	Approv





DES	GN W	DRAWN BY		AEROSPACE CHILD INTERNATIONAL A	
CHE	CKED	APPROVED	DRAWING NO. D2652		REV. A SHEET 1 OF 1
DATE	=		TITLE		SCALE
97	:03:25		BUSHING		1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAXOP COPY TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE THIRD TED

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WITHOUT NOTICE

NO.34074